

Date: Wednesday, 25/06/2008 12:00:05 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: STEP SPACER
<b>Job Number</b>	: 40087C		
<b>Estimate Number</b>	: 10356		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D2279
<b>This Issue</b>	: 25/06/2008	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D2279 REV D
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 37925C	<b>Drawing Revision</b>	: D
<b>Written By</b>	:	<b>Material</b>	:
<b>Checked &amp; Approved By</b>	: <u>JUL 08.6.25</u>	<b>Due Date</b>	: 07/07/2008
<b>Comment</b>	: Est Rev: A New Issue 05-11-07 JLM Est Rev: B Now on Waterjet 06-07-03 JLM	<b>Qty:</b>	12 Um: Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S040	2024-T3 .040 sheet
<b>Comment:</b> Qty.: 0.1544 sf(s)/Unit Total : 1.8522 sf(s) Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick (M2024T3S.040) Identify as D2279 Batch: <u>10757</u> <u>8-7-3</u>		
2.0	WATER JET	FLOW WATER JET
<b>Comment:</b> FLOW WATER JET 1-Cut as per Dwg D 2279 <u>8-7-3</u> Dwg Rev: <u>D</u> Prog Rev: <u>D</u> 2-Deburr if necessary <u>8-7-3</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
<b>Comment:</b> SECOND CHECK <u>08/07/08</u> <u>x18</u>		
5.0	BRAKE NC	NC BRAKE
<b>Comment:</b> NC BRAKE Form As per Dwg D2279 <u>08/10/14</u> <u>18</u> <u>08/10/29</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STEP SPACER

Job Number: 40087C

Part Number: D2279

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/29 (18)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

HL 08-10-30 (18)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FZ 08/10/30 (18)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

54/1/12 12/11/20 18

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/31 (18)

Job Completion



U 08/10/30

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

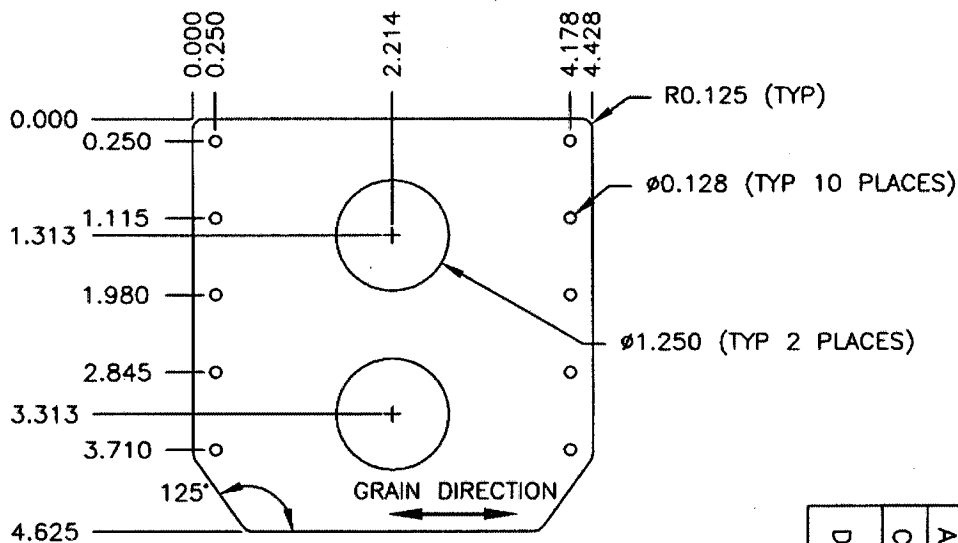
**NOTE:** Date & initial all entries







DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. D
BW	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
KE	JP	D2279	
DATE	TITLE	SCALE	
98.10.05	STEP SPACER	1:2	
A	94.10.13	NEW ISSUE	
C	94.11.15	0.588 WAS 1.607 AND 3.861 WAS 4.881	
D	98.10.05	4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER TSR A912	



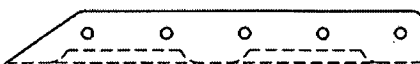
FLAT LAYOUT

FLANGE AFTER BENDING  
TOWARDS INSIDE OF PART  
USING DT8174 (2 PLACES)

R0.125

0.62

3.400



UNDER REVIEW

RELEASED  
98.10.08 DS

DESIGN OK, BUT CHECK WITH  
TS BEFORE MANUFACTURE

OK 9/9/09

MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
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WITHOUT NOTICE  
WORK ORDER  
400832